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*7314
Nov 12*

RBE105-31781W2-7
Job Sheet 185449



Part No: RBE105-31781W2-7

Job Qty: 5 ea

Part Name: 020.01 Pin



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/26/18

Job Tracking No:

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE105-31781W2 Rev.0 IPP Rev. A 18.10.25 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	11/9/18	11/9/18	0.00	0.00	Start Up Machining-2		<i>From 18-11-8</i>
110	Lathe Conv	5 pcs	11/9/18	11/9/18	0.00	1.25	Lathe Conv-1		<i>From 18-11-8</i>
120	QC	5 pcs	11/9/18	11/9/18	0.00	0.00	QC2 Machining-4		<i>From 18-11-8</i>
130	QC	5 pcs	11/9/18	11/9/18	0.00	0.00	QC8 Machining-4		<i>From 18-11-8</i>
140	Packaging	5 pcs	11/9/18	11/9/18	0.00	0.00	Packaging3-1		<i>From 18-11-8</i>
150	QC21-SA	5 Ea	11/9/18	11/9/18	0.00	0.00	QC21		<i>From 18-11-8</i>

Part Op Descriptions: 110 - 1-Machine as per DWG. DWG REV: _____ 2-Deburr

21 NOV 12 2018
9-89
GA

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R0.500	304 SS roundbar .500	.7100 ft (.142 ea)	90-Start up Operation	<i>S080895</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304R0.500	1	65	0

Part Specifications

Specifications could not be found.



Container No: S125889



Part: RBE105-31781W2-7

Job No: 185449

Serial No/Batch: S125889

Revision: 0

Inspector:

Exp Date:

Instructions:

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Date: 11/08/18

Plex 10/26/18 12:45 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

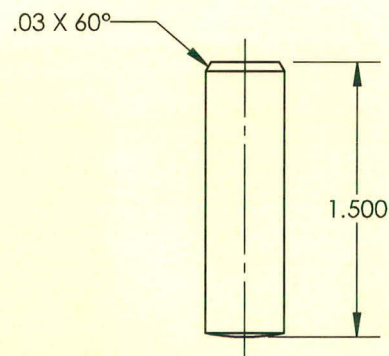
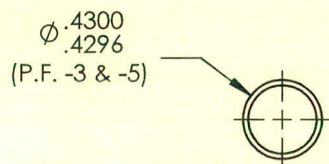
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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REVISIONS			
REV	ECR	DESCRIPTION	DATE
			INITIAL
			APPROVED



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WORK ORDER
NO. 18549 HCS
187026

(-7)

020.01 PIN

DART AEROSPACE	
TITLE MILLING TOOL	
DWG NO. RBE105-31781W2-7	REV
MAT'L SS 303/304/316	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX $\pm$.005 FRACTIONS $\pm$ 1/8
FINISH	.XX $\pm$.01 ANGLES $\pm$ 5°
SPEC	.X $\pm$.1 SURFACES = 125/✓
DRAWN BY: MACKOVJAK	1. BREAK ALL SHARP EDGES .015 x 45° OR .016R
CHECKED:	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR:	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR:	USED ON MODEL
APPROVED:	EC145, H145
SCALE 1:1	DATE 04/08/2017
SHEET 5 OF 12	

